

17/09

Date: Tuesday, 9/11/2007 10:56:23 AM  
 User: Chantal Lavoie

## Process Sheet

Customer	:	Drawing Name	:	COVER
Job Number	:	Part Number	:	D36413
Estimate Number	:	Drawing Number	:	D3641 UNDER REVIEW
P.O. Number	:	Project Number	:	N/A
This Issue	:	Drawing Revision	:	U/R
Prsht Rev.	:	Material	:	N/A
First Issue	:	Due Date	:	9/18/2007
Previous Run	:	Qty:	12	Um: Each
Written By	:			
Checked & Approved By	:			
Comment	:	Verified By:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6S032	6061-T6 Sheet 0.032"	
		Comment: Qty.: 0.8244 sf(s)/Unit Total : 9.8923 sf(s) M6061-T6 .032" THK sheet Batch: M18375 HB 07-09-12	 
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3641 Dwg Rev: A HB 07-09-12 Prog Rev: A	
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 07-09-12	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK Er 07/09/12 X/13	
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Form as per Dwg D3641 HB 07-09-13 <del>Spec sheet for drawing</del>	 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/10/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.09.12	S.0	120° ANGLE NOT ACHIEVED  2.50 IS 2.67	VE 07.09.12	ACCEPTABLE, PART WILL FUNCTION IN SERVICE AS INTENDED. NOT A STRUCTURAL PART.	VE 07.09.12	VE 07.09.12	EP QS1042	EP 07.09.13

NOTE: Date & initial all entries

Date: Tuesday, 9/11/2007 10:56:23 AM  
User: Chantal Lavoie

## Process Sheet

- Customer:

Drawing Name: COVER

Job Number: 34543

Part Number: D36413

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/13 x13

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

RJR 07-09-14

(13)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

En 07/09/14 Y13 counter

9.0 PACKAGING 1

PACKAGING RESOURCE #1



POSITIVE RECALL

Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock  
Location: 7/10/15 SC

07/09/14  
ENGINEERING APPROVAL  
APPROVAL

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/14  
ENGINEERING APPROVAL  
APPROVAL

13

Job Completion



POSITIVE RECALL

EFFECTIVE 07.09.13 AUTH ✓

RELEASED 16 DATE 07.10.15

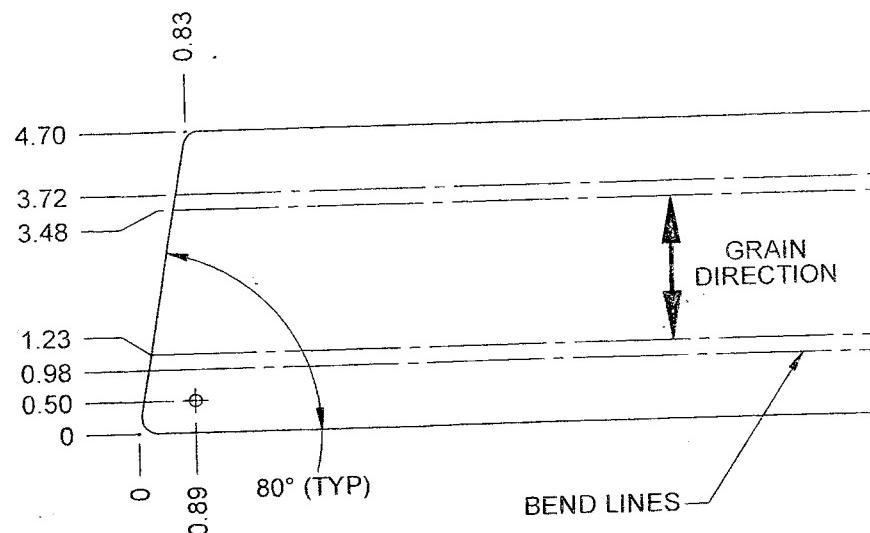
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

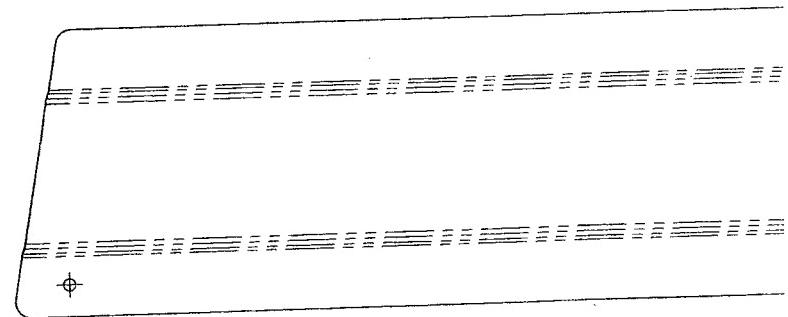
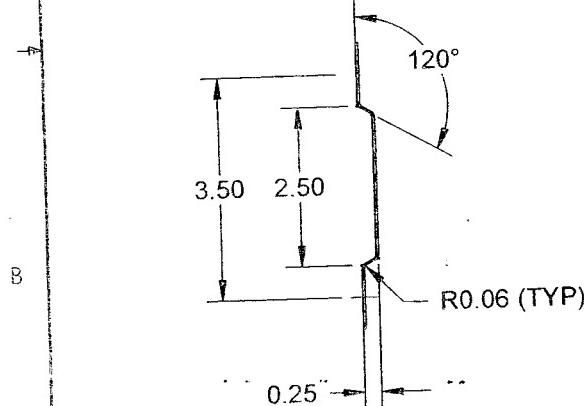
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D



C

D3641-3F FLAT

A

NOTES:  
1) MATERIAL: 6061-T6 (OR T62) ALUMINUM 0.032 THICK PER QQ-A-250/11 OR AMS 4025/4027

(REF DART SPEC M6061T6S.032)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART PIN "D3641-3I-4" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: 0.36 lbs

W/63454B

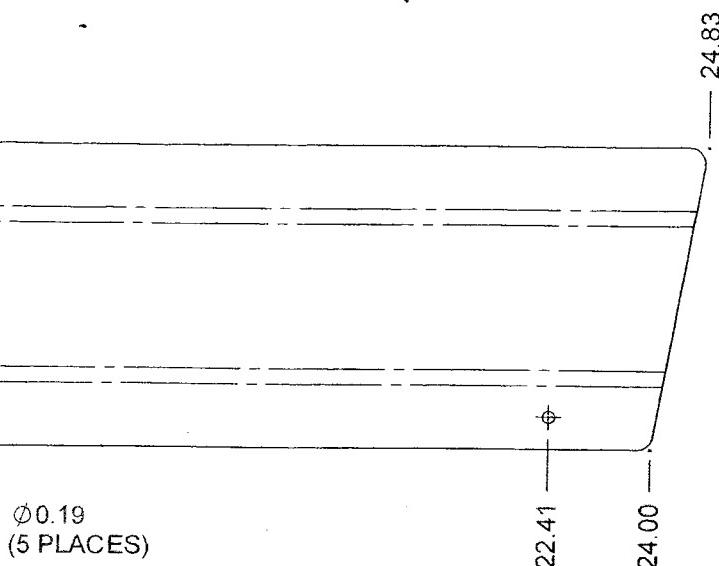
D3641  
(REPLACES GE)  
D3641-4  
(REPLACES GE)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



∅0.19  
(5 PLACES)

10606-5)

10606-4)

## PRELIMINARY ISSUE

07.09.07 16

DESIGN	TS	DART AEROSPACE USA, INC.
DRAWN	CJ	PORT HADLOCK, WA
CHECKED	B	DRAWING NO.
MFG. APPR.	E	D3641
APPROVED	MP	REV. A
DE APPR.		SHEET 2 OF 2
DATE	07.07.27	TITLE
		SCALE
		1:3
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

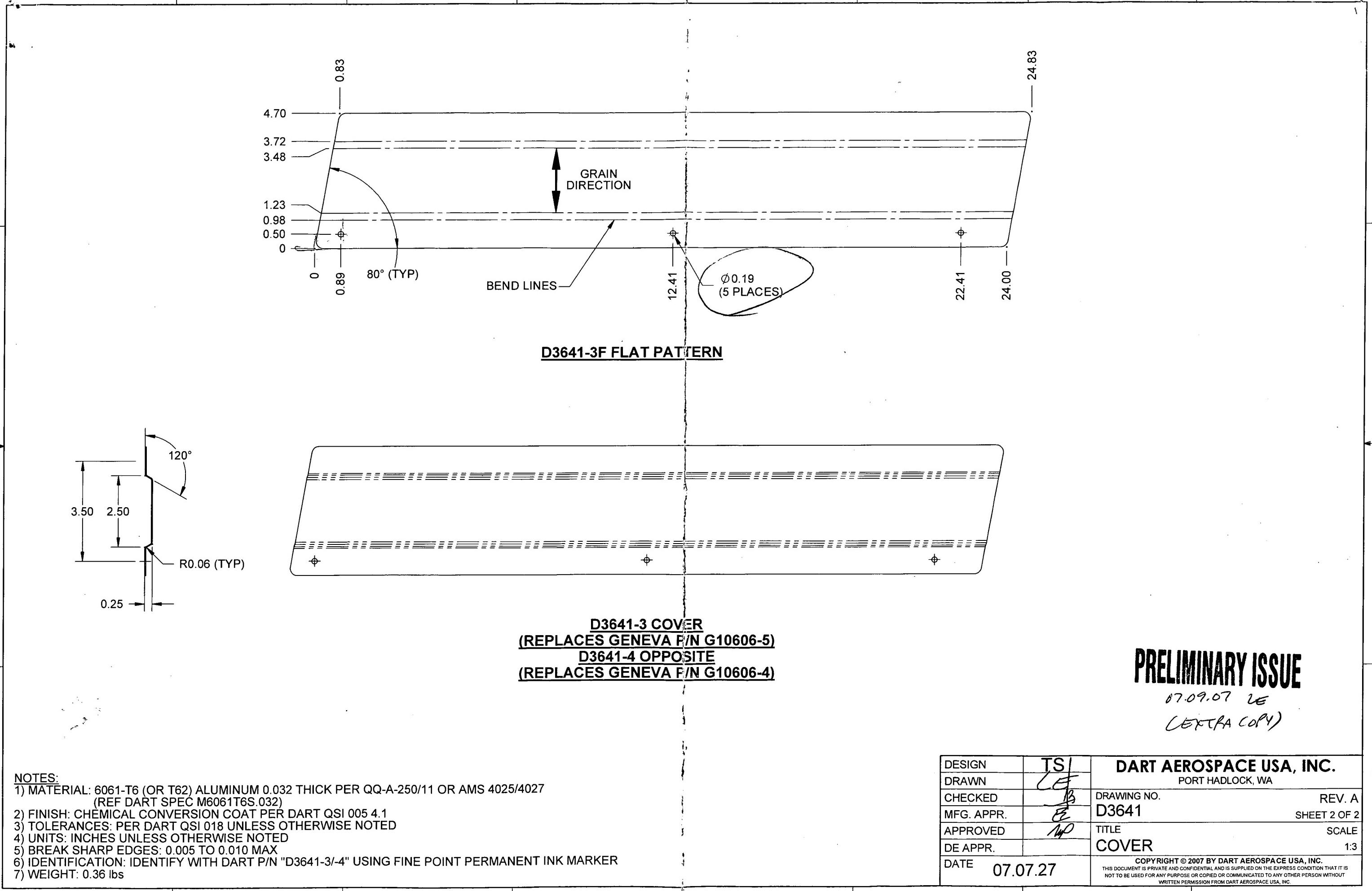
DART AEROSPACE LTD	Work Order:	34543
Description: COVER	Part Number:	D 3641-3
Inspection Dwg: D3641 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	HB	Audited by:	LP	Prototype Approval:	VS
Date:	07-09-12	Date:	7/09/12	Date:	07-09-12

Rev	Date	Change	Revised by	Approved
A		New Issue .	KJ/JLM	



# Non-Conformance Report

NCR  
08-112

Raised by:	Jason Murdoch	Source:	Q.C. Inspection	Sheet No. _____ of _____
Non-Conforming	Dept./Supplier: Prod - Packaging Stoves			Date: 08-11-12
Product/Service:	Shoulder harness kit (D350-764-011) D3641-3 & -4			Priority: HIGH LOW

Area of Standard:	Section A
QSI	Description of Non-Conformance : The -3 and -4 parts were mixed up & not identified correctly. They were stocked & identified as the opposite.
QSP	
QSPM	
Documents:	See also WO D350-764-011 B 43227.
P/O	
Invoice	
W/O	
Batch No.	34543 & 34544
TSR	Root Cause: The drawing was not verified when identifying the parts for stock. Lack of attention.
Drawing	D3641.

**REFERENCE ONLY**

Forward to Director, Quality Assurance on completion of Section A

DQA: Section B: Indicate who is responsible for creating C/A, and a completion date. Section C: Indicate who will verify completion of C/A.

**Section B** Responsible for Investigation/C/A: L.Lacelle To be done by: 08-11-20  
**Corrective Action**

No	Initial	Action Description	Responsible	Due date	Sign/Date
1	J.M	Determine affected kits. None in stock of the D350-764-011	L.Lacelle	08-11-12	08-11-12
2	J.M	Quarantine all stock. Note: 1x D3641-3 was found charged in w/o above.	J.M.	08-11-12	08-11-12
3	J.M.	Re-identify stock: QTY 1 -4 B34544 → now -3 B 34543	J.M.	08-11-12	08-11-12
4	J.M.	Ensure all employee's are aware to verify the drawing in relation to the part when identifying, and to ask questions if they are uncertain of the views on the drawing. Re-train the employee's on how to interpret the drawing, and views.	J.M.	08-11-12	08-11-12
5	J.M	Attach a copy of the NCR & the original copy of all the affected W/O's.	J.M.	08-11-20	08-11-20

Fault Category:  
Prod - Stoves packaging

**Section C** Responsible for Verification of CA: S.Sheld Date: \_\_\_\_\_

No	Verification Method	Sign	Date	Forward to DQA on Completion of Verification
1				
2	Discussed w/ Peer Review		08-11-20	
3				
4	System in place to prevent recurrence			DQA: _____
5				Date: _____

QA Purposes only

N/C Closed

Date